

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008698**Date Inspected:** 14-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhan Hai Feng/**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Bay #3**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-( FB012-034-002, 010, 013, 014, 033, 034, 041, 042)

-( FB003-200-011, 012, 015, 016, 039, 040, 017, 018, 027, 028)

-( FB003-191-011, 012, 015, 016, 039, 040, 017, 018, 027, 028)

**Bay #3**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-( SSD19-PP107-136, SSD19-PP102-136, FB003-200-020, 032, 022, FB003-191-020, 022)

**Bay #2**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-( FB3045-001-001, 022)

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-( FB3098-001-019)  
-( FB3097-001-017, 018)  
-( FB3026-001-013, 014)  
-( FB3012-003-001, 016, 017)  
-( FB3083-001-001, 016, 017)  
-( FB3012-002-001, 016, 017)  
-( FB3012-001-001, 016, 017)  
-( FB3083-003-001, 016, 017)  
-( FB3093-001-019, 018)  
-( FB3025-001-013, 014)  
-( FB3024-001-001, 018)  
-( FB3095-001-017, 018)  
-( FB3013-001-001, 016, 017)  
-( FB3091-001-001, 016, 017)  
-( FB3089-001-001, 014, 017)  
-( FB3030-001-001)  
-( FB3090-001-001, 014, 015)

### Bay #9

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-( DP3040-001-013~014)  
-( DP3013-001-089, 090)  
-( DP3013-001-099, 100)

### Bay #3

This QA inspector observed that all the required NDT work completed on following items and ready for green tag. This QA Inspector issued green tag for the following items. The member is identified as OBGComponents. The weld designations reviewed are as follows:

CA078-077, 078 10236  
CA078-063, 064 10237  
CA078-049, 050 10238  
CA078-035, 036 10239  
CA078-021, 022 10240  
CA076-123, 124 10241  
CA076-109, 110 10242  
CA076-095, 096 10243  
CA076-081, 082 10244  
CA076-067, 068 10245  
CA076-053, 054 10246  
CA076-039, 040 10247  
CA076-025, 026 10248  
CA075-115, 116 10249

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CA075-101, 102 10250  
CA075-087, 088 10251  
CA075-073, 074 10252  
CA075-059, 060 10253  
CA075-045, 046 10254  
CA075-031, 032 10255  
CA075-017, 018 10256  
CA072-081, 082 10257  
CA072-069, 070 10258  
CA072-057, 058 10259  
CA072-045, 046 10260  
CA072-033, 034 10261  
CA072-021, 022 10262  
CA078-091, 092 10213

This QA inspector observed the following work in progress:

Bay#2

Joint fit-up verified by SMAW welding process of weld joint FB3080-001-023, 031 located on FB3080-001. Welder is identified as 020569 (1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS

SAW welding of weld joint FB3086-001-023, 031 located on FB3086-001. Welder is identified as 207237(1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint FB6502-001-023, 031 located on FB6502-001. Welder is identified as 062438 (1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint FB3099-001-023, 031 located on FB3099-001. Welder is identified as 062438 (1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint FB3027-001-023, 031 located on FB3027-001. Welder is identified as 062438 (1G). ZPMC QC-CWI is identified as Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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